



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6510G07931-6F-1

Job Sheet 199068



Part No: RBW6510G07931-6F-1

Job Qty: 2 pcs *6 pcs inf*

Part Name: 189/139 Reaction Block Pin



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/12/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 10/21/19

Description:

Type: SOLD

Note: DWG RBW6510G07931-6F Rev A IPP Rev. A 19.08.02 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	
100	SL-154 - 1	2 pcs	10/21/19	10/21/19	1.00	0.40	SL-154 - 1
110	QC 2	2 pcs	10/21/19	10/21/19	0.00	0.00	QC 2 - 1
							QC 2 - 12
							QC 2 - 14
							QC 2 - 17
							QC 2 - 19
							QC 2 - 2
							QC 2 - 20
							QC 2 - 22
							QC 2 - 23
							QC 2 - 25
							QC 2 - 32
							QC 2 - 33
							QC 2 - 35
							QC 2 - 39
							QC 2 - 4
							QC 2 - 40
							QC 2 - 44
							QC 2 - 45
							QC 2 - 48
							QC 2 - 49
							QC 2 - 50
							QC 2 - 51
							QC 2 - 52
							QC 2 - 57
							QC 2 - 62
							QC 2 - 63
							QC 2 - 8
							QC 2 - 66
							QC 2 - 64
							QC 2 - 65



Container No: S218382



Part: RBW6510G07931-6F-1

Job No: 199068

Serial No/Batch: S218382

Revision: A

Inspector:

Exp Date:

Instructions:

1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/30/19

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120	QC 8	2 pcs	10/21/19	0.00 0.00	QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	OK 19/10/04
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
130	Outsource - 12 - Black Oxide	2 pcs	10/21/19		GRO002-VC PO HBCN 719 CZ OCT 08 2019	OK
140	Packaging 2-1 - Receive - B4B	2 pcs	10/21/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
150	QC 6	2 pcs	10/21/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	OCT 22 2019
					QC 6 - 61	
					DAS 68 9-89	
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				QC 6 - 40	
				QC 6 - 81	
160	Packaging 3-1 - Stock - B4B	2 pcs	10/21/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
170	QC 21 - SA	2 pcs	10/21/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op 100 - 1-Machine as per folio FC 949 FOLIO REV: AA DWG REV: A 2-Deburr
 Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB
 120 - QC8- Inspect parts - second check
 130 - -Issue P/O; _____ -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type;
 4140 -Certificate of Conformity is required
 140 - (Receive & Inspect for Damage & Mat'l Certs) Certificate of Conformity is required
 150 - QC6- All purchased or subcontracted products
 160 - Identify as per dwg & Stock Location: _____
 170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140QT-R1.125	AISI 4140 Quenched & Tempered Steel Round Bar 1.125" Dia.	.5400 ft (.27 ea)	100-SL-154 - 1	<u>5187867</u> 26"

Job Allocations

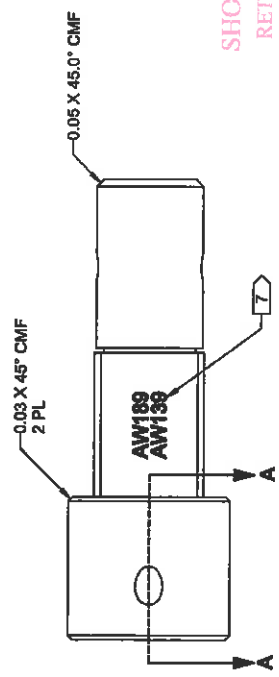
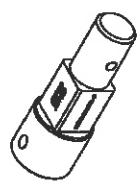
Operation	Component Part	Required	Inventory	Allocated
100-SL-154 - 1	MT-4140QT-R1.125	1	17	0

Part Specifications

Specifications could not be found.

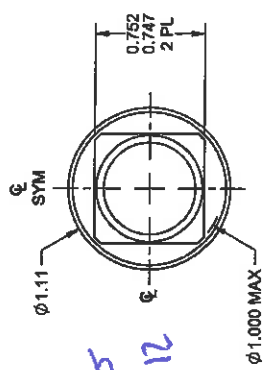
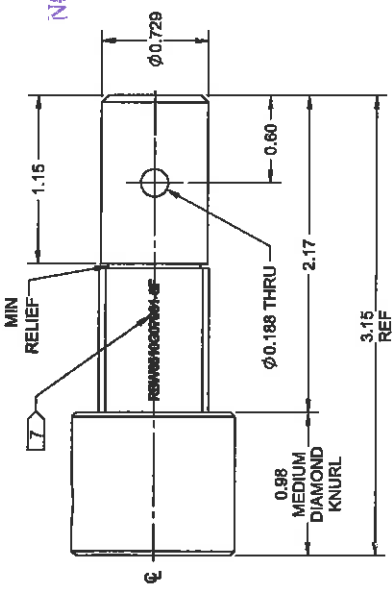
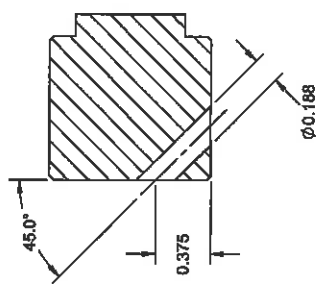
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8 7 6 5 4 3 2 1



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED (C)
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 199008

SECTION A-A



RBW6510G07931-6F-1 189/139 REACTION BLOCK PIN

- NOTES:
- 1) MATERIAL: 4140 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: BLACK OXIDE PER MIL-C-13024 CLASS 1 THEN APPLY A THIN LAYER OF OIL CPC PER MIL-PRF-18173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
 - 4) TOLERANCES: XX = ± 0.01 / ± 0.5
XXX = ± 0.005 / ± 0.1
XXXX = ± 0.0005 / ± 0.05
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: MACHINE ENGRAVE AS SHOWN

DESIGN	KPT	TOOL PART #	REV. A
DRAWN	KPT	RBW6510G07931-6F	SHEET 2 OF 2
CHECKED	ZF	TITLE	SCALE
MFG. APPR.	JFC	189/139 REACTION BLOCK PIN ASSEMBLY	NTS
APPROVED			
DATE	2019-05-24		

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WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

1

Job: _____		DISPOSITION		DEPARTMENT/PROCESS							
Part No. _____		Rework ☐ Scrap ☐ Use-as-is ☐		Skid-tube ☐ Machining ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐		Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐		Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date :		Sequence #:		QTY Affected :		MRB (QS1042)					
Description Work Order Deviation				Disposition							
Completed By				Lead hand / Supervisor							
QC / QA Coordinator											

Root Cause		FAULT CATEGORY													
Operator	☐	Pressure/Forced	☐	Contamination	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Operator	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Manufacturing Process	☐	Bending	☐	Misaligned/off center	☐	Folio/Program	☐	Outside Tolerance	☐	Manufacturing	☐	Folio/Program	☐	Outside Tolerance	☐
Equip/Tooling	☐	Crushing	☐	BOM/Route	☐	Grain Direction	☐	Drawing	☐	Tooling	☐	Grain Direction	☐	Drawing	☐
Handling/Preservation	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Finish	☐	Material	☐	Weld	☐	Finish	☐
Material	☐	Crimp/Kink/Ripple/Wave/Twist	☐	Incomplete/Unclear Instructions	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Product Improvement	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Product Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Out of Sequence	☐	Misread	☐	Process Improvement	☐	Out of Sequence	☐	Misread	☐
Human Factors	☐	Mislabeled	☐	Fit/Function	☐	Off-set/Set-up	☐			Human Factors	☐	Off-set/Set-up	☐		
		Other/Details:													



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044718



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3668
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044718

PO Date: 10/8/19

Due Date: 10/16/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Lavoie, Chantal
Phone: 613-623-5200 Ext: 242
Fax: 613-632-1053
clavoie@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

OCT 08 2019

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	201400	RBW5605G00351- 3G-1	Shoe -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-c- 81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	10/16/19	9 pcs	0 pcs	9 pcs	\$2.00/pcs	\$18.00

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OCT 12 2019

DP



Dart Aerospace Ltd.
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PURCHASE ORDER

POHB044718



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	901402	RBW5605G00551-3G-1	Shoe -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed - X9		10/16/19	9 pcs	0 pcs	9 pcs	\$2.00/pcs	\$18.00
						OCT 21 2019					
3	94256	RBGTMD12	Main Rotor Pillow Block Bolt Socket -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; DOM -Certificate of Conformity is required	Firmed - X6		10/16/19	6 pcs	0 pcs	6 pcs	\$2.00/pcs	\$12.00
						OCT 21 2019					



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PURCHASE ORDER

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Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	199067	RBW6510G08031-6F-1	169 Reaction Block Pin -Issue P/O: -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed -		10/16/19	6 pcs	0 pcs	6 pcs	\$2.00/pcs	\$12.00
5	199068	RBW6510G07931-6F-1	189/139 Reaction Block Pin -Issue P/O: -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed -		10/16/19	6 pcs	0 pcs	6 pcs	\$2.00/pcs	\$12.00



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PURCHASE ORDER

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Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	199049	RBW6510G05731-6F-4	Pin -Issue P/O: -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-c- 81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	10/16/19	24 pcs	0 pcs	24 pcs	\$2.00/pcs	\$48.00
Grand Total:											\$120.00

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/9/19 9:20 AM Dart.Lavoie.Chantal



Certificat de Conformité / Certificate of Compliance

(023087-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

023087 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
18-Oct-2019		Jigar Patel		POHB044718					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order	
1	RBW5605G00351-3G-1 Rev.	RBW5605G00351-3G-1 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	9	9	0	0	0	
2	RBW5605G00551-3G-1 Rev.	RBW5605G00551-3G-1 O1 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL MIL-PRF-16173 GRADE 3 CLASS 1 WIPE OFF EXCESS OIL	OXIDE-BLACK CH	9	9	0	0	0	
3	RBGTMD12 Rev.	RBGTMD12 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	6	6	0	0	0	
4	RBW6510G08031-6F-1 Rev.	RBW6510G08031-6F-1 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	6	6	0	0	0	
5	RBW6510G07931-6F-1 Rev.	RBW6510G07931-6F-1 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	6	6	0	0	0	
6	RBW6510G05731-6F-4 Rev.	RBW6510G05731-6F-4 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	24	24	0	0	0	

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 DART AEROSPACE LTD.

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CANADA
BUYER:

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Réçu par
Received By

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements. Our financial and legal responsibility will not be higher than the amount of invoice.